



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.9715

Job Sheet 210880



split 10

HAAS mk

Part No: 646.9715

Job Qty: 10 pcs

Part Name: Body



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/25/20

Job Tracking No:

Due Date: 7/17/20

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG 646.9700 REV.J IPP REV A 19.09.13 NEW ISSUE RQ VERIFIED BY DD IPP REV:B 2020.05.22 AS
PER DWG REV.J DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
110	HAAS 4 Axis	10 pcs	7/3/20		0.22	5.00	HAAS - 1	ALA
							HAAS - 2	
							HAAS - 3	
							HAAS - 4	
120	QC 2	10 pcs	7/3/20		0.00	0.00	QC 2 - 1	ALA
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	



Container No: S289171



Part: 646.9715

Job No: 210880

Serial No/Batch: S289171

Revision: Rev.J

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 07/20/20

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					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 2 - 76	
					QC 2 - 86	
					QC 2 - 83	
130	QC 8	10 pcs	7/3/20	0.00 0.00	QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	JC-L-20-07-27
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
					QC 8 - 66	
					QC 8 - 73	
					QC 8 - 82	
140	Outsource - 4 - Anodize	10 pcs	7/17/20		ATG001-VC	10
150	Packaging 2-1 - Receive - B4B	10 pcs	7/17/20	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	

				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
				Packaging 2 - 37 - B4B	
155	QC 6	10 pcs	7/17/20	0.00 0.00	QC 6 - 9
					QC 6 - 68
					QC 6 - 61
					QC 6 - 40
					QC 6 - 81
					QC 6 - 82
180	Packaging 3-1 - Stock - B4B	10 pcs	7/17/20	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B

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				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
190 QC 21 - SA	10 pcs	7/17/20	0.00 0.00	QC 21 - SA - 21	DAS AUG 12 2020
				QC 21 - SA - 70	21
				QC 21 - SA - 9	9-89
				QC 21 - SA - 77	

Part Op **110** - 1-Machine as per folio FC974 FOLIO REV: AA DWG REV: J 2-Deburr

Descriptions: **120** - (QC2- Inspect parts off machine FAI/FAIB)

130 - (QC8- Inspect parts - second check)

140 - Issue P/O to ATG: 46802 AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.2, PRIME AS PER IAW MIL-PRF-23377 TYPE 1 CLASS N Certification of Conformity is required

150 - (Receive & Inspect for Damage & Mat'l Certs)

155 - (QC6- All purchased or subcontracted products)

180 - (Identify as per dwg & Stock Location: _____), ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

190 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M7075T6S1.000X5.000	7075-T6 Sheet1" Thick Plate X 5" Wide	6,2100 ft (.621 ea) <u>7.430"</u>	110-HAAS 4 Axis	<u>S288633</u>

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-HAAS 4 Axis	M7075T6S1.000X5.000	6	0	0

Part Specifications	
Specifications could not be found.	

DART AEROSPACE LTD		Work Order: 210880
Description: Cutter Sub Assembly		Part Number: 646,9715
Inspection Dwg: 646,9700 Rev: J		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.960	+/- .002	3.961			HG	3/006
1.181	+/- .002	1.181			"	"
3.004	+/- .002	3.004			"	"
3.711	+/- .002	3.7115			"	"
1.181	+/- .002	1.181			"	"
2.862	+/- .002	2.863			"	"
1.181	+/- .002	1.181			"	"
2.719	+/- .002	2.7195			"	"
3.461	+/- .002	3.4615			"	"
.361	+/- .002	.3615			"	"
.373	+/- .002	.3735			"	"
.385	+/- .002	.3855			"	"
.396	+/- .002	.397			"	"
.407	+/- .002	.4065			"	"
7.026	+/- .005	7.027			VREN	B18017739
.485	+/- .002	.4845			HG	3/006
2.178	+/- .002	2.177			"	"
2.259	+/- .002	2.2585			"	"
2.580	+/- .002	2.5795			"	"
3.378	+/- .002	3.3775			"	"
3.451	+/- .002	3.450			"	"
4.578	+/- .002	4.5775			"	"
4.642	+/- .002	4.641			"	"
4.675	+/- .002	4.6745			"	"
2.237	+/- .002	2.2365			"	"
3.418	+/- .002	3.418			"	"
4.600	+/- .002	4.6005			"	"
5.622	+/- .002	5.6215			"	"
6.647	+/- .002	6.646			"	"
Ø .177	+/- .005	.177			GP	Ref.
Ø .201	+/- .005	.202			GP	Ref.
4.358	+/- .005	4.359			HU	3/006

Measured by: N/A	Checked by: J.C.L.	QC Inspector:
Date: 20/07/20	Date: 20.07.21	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB046802



Supplier: ATG001-VC
A.T.G. Industries Inc
760 INDUSTRIELLE STREET
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB046802

PO Date: 7/28/20

Due Date: 8/7/20

Purchase Order

Revision:

Revision Date:

Issued By: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pynt Terms: Net 60

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	211044	646.2910	646.2900 Rev N/C	Deflector : Various STC's (Outsource process- Anodize per QSI017 4.1.10.1) Issue P/O to ATG : Hard Anodize, Color Black / Prime As per Dwg 646.2900 Rev. N/C	Firmed	-	8/7/20	12 pcs	0 pcs	12 pcs	\$49.73/pcs	\$596.76



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PURCHASE ORDER

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Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
2	210880	646.9715	646.9700 Rev.J	Body : Various STC's Issue P/O to ATG: AS PER MPP- 172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A- 8625 TYPE 3 CLASS 2 AS PER MPP- 172 SECTION 4.2, PRIME AS PER IAW MIL- PRF-23377 TYPE 1 CLASS N Certification of Conformity is required	Firmed	-	8/7/20	10 pcs	0 pcs	10 pcs	\$16.23/pcs	\$162.30
					X10						AUG 11 2020	
3	210465	D4824-1	D4824 Rev A	Upper Cutter Mount : Certificate of Conformity only Issue P/O: Black Anodize as per Dwg D4824 PRIME AS PER DWG, SEE NOTE #2	Firmed	-	8/7/20	7 pcs	0 pcs	7 pcs	\$15.13/pcs	\$105.91
					X7						AUG 11 2020	

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PURCHASE ORDER

POHB046802



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	210369	646.9713	646.9700 Rev.J	Body Issue P/O to ATG: AS PER MPP- 172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A- 8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.2, PRIME AS PER IAW MIL- PRF-23377 TYPE 1 CLASS N Certification of Conformity is required	Firmed X10	-	8/7/20	10 pcs	0 pcs	10 pcs	\$16.23/pcs	\$162.30
5	209021	646.9910	646.9900 Rev nc1	Struts Issue P/O to ATG : Hard Anodize, Color Black and Prime as per Dwg 646.9900 rev. N/C	Firmed X15	-	8/7/20	15 pcs	0 pcs	15 pcs	\$15.13/pcs	\$226.95
6	210883-A	647.1515	647.1500 Rev E	Upper Deflector : Various STC's (Outsource process- Anodize per QSI017 4.1.10.1) Issue P/O to ATG :	Firmed X2	-	8/7/20	2 pcs	0 pcs	2 pcs	\$13.78/pcs	\$27.56



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PURCHASE ORDER

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Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
7	211201	D5771-15	D5771 REV.A	Curved Washer -Issue P/O; ANODIZE BLACK PER MIL-A-8625 TYPE 2 CLASS 2 -Material type; 6061T6 -Certificate of Conformity is required	Firmed X8	-	8/7/20	8 pcs AUG 11 2020	0 pcs	8 pcs	\$6.41/pcs	\$51.28
8	211206	D5771-13	D5771 REV.A	Crescent Bushing -Issue P/O; ANODIZE BLACK PER MIL-A-8625 TYPE 2 CLASS 2 -Material type; 6061T6 -Certificate of Conformity is required	Firmed X8	-	8/7/20	8 pcs AUG 11 2020	0 pcs	8 pcs	\$6.41/pcs	\$51.28
Grand Total:											\$1,384.34	

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Guerrin



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 920618

Date: 10-Aug-20

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
10 ea	Part: 646.9715 Body Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Batch/Lot#: Job: 27849 PO: POHB046802		Rev: J Expiry Date: Line: 2
10 ea	Part: 646.9713 Body Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Batch/Lot#: Job: 27862 PO: POHB046802		Rev: J Expiry Date: Line: 4
15 ea	Part: 646.9910 Struts Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Batch/Lot#: Job: 27899 PO: POHB046802		Rev: NC Expiry Date: Line: 5

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DART AEROSPACE LTD.

Made in Canada.

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RECEIVED
AUG 11 2020
DART AEROSPACE LTD.



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 920618

Date: 10-Aug-20

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms	Ship Via
	ATG Delivery
Quantity	Description
	CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>AUG 10 2020</u> Certified Signature: <u></u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt. Made in Canada.